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RBE1120-31502W1
Job Sheet 185460



Part No: RBE1120-31502W1

Job Qty: 2 ea

Part Name: Press-In & Push-Out Device



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE1120-31502W1 Rev.1 IPP Rev. A 18.10.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	1 pcs		11/16/18	0.00	1.00	Small Fab-3		MLC DAS 30
120	QC	1 pcs		11/16/18	0.00	0.00	QC5		MLC DAS 30
130	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging3-1		MLC DAS 30
140	QC21-FG	1 Ea		11/16/18	0.00	0.00	QC21		MLC DAS 30

Part Op
Descriptions: 110 - 1-Assemble as per DWG. See note 2 and 3.

DEC 27 2018 70 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98381A512	Dowel Pin, Small Ø 3/16 X 1-1/4	21 (1 ea)	90-Start up Operation	5124978
98381A544	Dowel Pin, Large Ø 1/4 X 1-1/4	21 (1 ea)	90-Start up Operation	5139511
RBE1120-31502W1-1	Base	21 Ea (1 ea)	110-Small Fab	5135853
RBE1120-31502W1-3	Top	21 Ea (1 ea)	110-Small Fab	5136510
RBE1120-31502W1-5	Bushing 1	21 Ea (1 ea)	110-Small Fab	5137429
RBE1120-31502W1-7	Bushing 2	21 Ea (1 ea)	110-Small Fab	5137479
RBE1120-31502W1-9	Pin	21 Ea (1 ea)	110-Small Fab	5135050

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	98381A512	1	0	0
	98381A544	1	0	0
110-Small Fab	RBE1120-31502W1-1	1	0	0
	RBE1120-31502W1-3	1	0	0
	RBE1120-31502W1-5	1	0	0
	RBE1120-31502W1-7	1	0	0
	RBE1120-31502W1-9	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

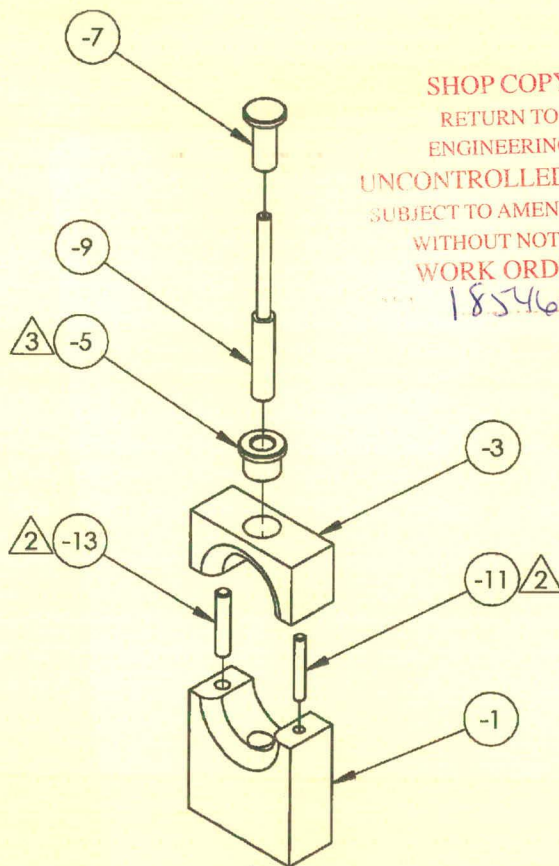
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					

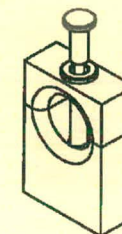
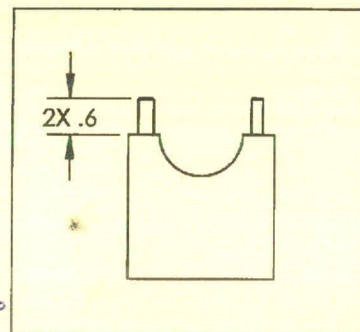
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5 REMOVED B/O INFORMATION AND SPECIFICATION. MATERIAL WAS STEEL IS 01, DIM WAS (Ø .625) IS Ø .6250 +.0017/+0014, DIM WAS (Ø .375) IS Ø .3750 +.0005/+0001, DIM WAS (Ø .797) IS Ø .80, DIM WAS 3X .03 X 45° IS 4X .03 X 45°.	18/10/2018	KPT	



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

185460
mcs
18-10-26



NOTES:

1. REF. AIRBUS T/N: 1120-31502W1.

2. APPLY LOCTITE 620 ONTO MATING SURFACES AND PRESS INTO -1.

3. APPLY LOCTITE 620 ONTO MATING SURFACES AND PRESS INTO -3.

DART AEROSPACE																					
TITLE PRESS IN/PUSH OUT DEVICE																					
DWG NO. RBE1120-31502W1	REV 1																				
<table border="1"> <tr> <td>MAT'L STEEL</td> <td>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH ZINC PLATED</td> <td>XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>JX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>X ± .1 SURFACES = 125</td> </tr> <tr> <td>DRAWN BY: [Signature]</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>CHECKED: [Signature]</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>OPPS APPR:</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>QA APPR:</td> <td>USED ON MODEL</td> </tr> <tr> <td>APPROVED: [Signature]</td> <td>EC145, EC645</td> </tr> <tr> <td>SCALE 1:3</td> <td>DATE 08/08/2016</td> </tr> </table>		MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	FINISH ZINC PLATED	XXX ± .005 FRACTIONS ± 1/8	SPEC	JX ± .01 ANGLES ± 5°		X ± .1 SURFACES = 125	DRAWN BY: [Signature]	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	CHECKED: [Signature]	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	OPPS APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	QA APPR:	USED ON MODEL	APPROVED: [Signature]	EC145, EC645	SCALE 1:3	DATE 08/08/2016
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APPROVED: [Signature]	EC145, EC645																				
SCALE 1:3	DATE 08/08/2016																				

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	A36/1018/1020 HR		2
			-3	1	TOP	A36/1018/1020 HR		3
			-5	1	BUSHING 1	O1		4
			-7	1	BUSHING 2	O1		5
			-9	1	PIN	O1		6
		B/O	-11	1	DOWEL PIN, SMALL	STEEL	Ø3/16 X 1-1/4 (MCMASTER-CARR # 98381A512)	1
		B/O	-13	1	DOWEL PIN, LARGE	STEEL	Ø1/4 X 1-1/4 (MCMASTER-CARR # 98381A544)	1



Container No: S140386



Part: RBE1120-31502W1

Job No: 185460

Serial No/Batch: S140386

Revision: 1

Inspector:

Exp Date:

Instructions:

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www.dartaerospace.com

Date: 12/27/18